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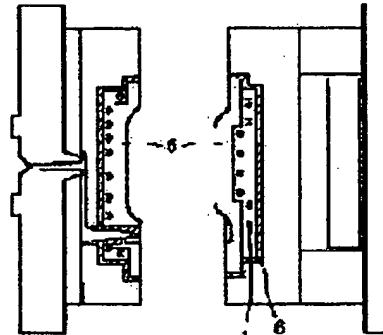
(21)Application number : 11-087795 (71)Applicant : ASAHI CHEM IND CO LTD
(22)Date of filing : 30.03.1999 (72)Inventor : TAKANO FUMIYOSHI
YASUDA KAZUHARU

(54) INSERT INJECTION MOLDING METHOD

(57)Abstract:

PROBLEM TO BE SOLVED: To obtain a strong integration force between a thermoplastic resin and an insert material and to obtain an article free from wrinkles and breakage by heating and cooling a mold after the molten resin being injected/packed into the mold in which a cloth of the insert material is arranged.

SOLUTION: A stretchable cloth to which a conductive material is adhered is put in a mold, a molten thermoplastic resin is injected/packed from one side of the cloth after mold clamping to make the cloth adherent to the resin. The inner surface of the mold is formed from a mold inner surface member 5 comprising a derivative, each induction coil 4 is arranged in the back part of the member 5, a shielding plate 6 comprising a non-derivative is arranged in the back part of its area, the heating of parts other than the member 5 is cut off, and the member 5 is high frequency induction-heated selectively. The mold is heated, a resin surface layer is fluidized again, the resin is made to penetrate into the cloth to be pushed out to the surface side of the cloth through the meshes to cover the surface of the cloth partially or entirely. In this way, the cloth is integrated strongly with the resin to be an article which has electromagnetic wave shielding properties and is free from wrinkles and breakage.



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